

and in their operation, may be made by those skilled in the art without departing from the spirit of the present invention. For example, it is expressly intended that all combinations of those elements and or method steps which perform substantially the same function in substantially the same way to achieve the same results are within the scope of the invention. Substitutions of elements from one described embodiment to another are also fully intended and contemplated. It is the intention, therefore, to be limited only as indicated by the scope of the claims appended hereto.--.

Page 9, line 1, change "Claims:" to - What is claimed is:--.

IN THE ABSTRACT:

In the title, delete "(57)".

Line 1, after "A method" insert --and apparatus--.

Line 3, change "According to the method, at" to --At--.

IN THE CLAIMS:

Cancel claims 1 to 13, without prejudice.

Add the following new claims:

14. A method for calendering paper and board when manufacturing coated grades of paper or board comprising:

calendering at least one of the surfaces of an uncoated base material web with a shoe calender having a nip length of at least 50 mm;

applying at least one layer of coating at least onto the calendered surface of the base web; and

calendering the coated surface of the base web with a calender having a nip length of no more than 50 mm.

15. The method of claim 14, wherein the uncoated surface of the base web is calendered with a shoe calender having a nip length of 50 to 270 mm.

16. The method of claim 14, wherein the coated surface of the base web is calendered with a belt calender having a nip formed between two rolls.

17. The method of claim 14, wherein the coated surface of the base web is calendered with a belt calender having a nip formed by means of a short shoe.

18. The method of claim 14, wherein the uncoated surface of the base web is calendered with a shoe calender having a shoe divided into sectors in a travel direction of the web, a compression load of the sectors being independently controllable.

19. The method of claim 16, wherein the uncoated surface of the base web is calendered with a shoe calender having a shoe divided into sectors in a travel direction of the web, a compression load of the sectors being independently controllable.

20. The method of claim 17, wherein the uncoated surface of the base web is calendered with a shoe calender having a shoe divided into sectors in a travel direction of the web, a compression load of the sectors being independently controllable.

21. The method of claim 15, wherein pressure applied to the uncoated surface of the base web by the shoe calender is from 0 to 15 MPa.

22. The method of claim 15, wherein pressure applied to the uncoated surface of the base web by the shoe calender is from 4 to 12 MPa.

23. The method of claim 14, further comprising heating the base web such that surface fibers thereof are at at least a glass transition temperature when the base web enters the shoe calender.

24. The method of claim 21, further comprising heating the base web such that surface fibers thereof are at at least a glass transition temperature when the base web enters the shoe calender.

25. The method of claim 23, wherein the base web is heated with the aid of one of pre-wetting, pre-steaming and heating the web with a heated backing roll.

26. The method of claim 24, wherein the base web is heated with the aid of one of pre-wetting, pre-steaming and heating the web with a heated backing roll.

27. An apparatus for calendering paper and board when manufacturing coated grades of paper or board comprising:

a first calender for calendering at least one of the surfaces of an uncoated base material web, the first calender comprising a shoe calender having a nip length of at least 50 mm;

a means for applying at least one layer of coating at least onto the calendered surface of the base web; and

a second calender for calendering at least the coated surface of the base web, the second calender having a nip length of no more than 50 mm.

28. The apparatus of claim 27, wherein the shoe calender having a nip length of 50 to 270 mm.

39. The apparatus of claim 27, wherein the second calender is a belt calender having a nip formed between two rolls.

30. The apparatus of claim 27, wherein the second calender is a belt calender having a nip formed by means of a short shoe.

31. The apparatus of claim 27, wherein the shoe calender has a shoe divided into sectors in a travel direction of the web, a compression load of the sectors being independently controllable

32. The apparatus of claim 28, wherein the shoe calender has a shoe divided into sectors in a travel direction of the web, a compression load of the sectors being independently controllable

33. The apparatus of claim 29, wherein the shoe calender has a shoe divided into sectors in a travel direction of the web, a compression load of the sectors being independently controllable

34. The apparatus of claim 30, wherein the shoe calender has a shoe divided into sectors in a travel direction of the web, a compression load of the sectors being independently controllable